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D4148-1
Job Sheet 194371



Part No: D4148-1

Job Qty: 20 pcs

Part Name: Crosstube Lug Plate, Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/1/19

Job Tracking No:

Due Date: 5/31/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E SHEET 1 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.10.29 as per revC DD verf:EC
IPP REV:C 11.03.02 AS PER DWG REV.D DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs	5/31/19	5/31/19	0.06	4.31	Waterjet - Flow		JRB
110	QC 2	20 pcs	5/31/19	5/31/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		SRO
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	20 pcs	5/31/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
150 Packaging 3-1 - Stock - B4B	20 pcs	5/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

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				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	20 pcs	5/31/19	0.00 0.00	QC 21 - SA - 21	206
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9.55

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Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	7.2140 sf (.3607 ea)	100-Waterjet - Flow - 1	5159397

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	7	97	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Crosstube Lug Plate	0.129Inches + 0.005 - 0.001	0.134 0.128		0.129
2	Fwd Crosstube Lug Plate	0.191Inches + 0.005 - 0.001	0.196 0.190		0.1905
3	Fwd Crosstube Lug Plate	0.380Inches + 0.006 - 0.001	0.386 0.379	*	0.379
4	Fwd Crosstube Lug Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	J	0.256
5	Fwd Crosstube Lug Plate	0.500Inches + 0.008 - 0.001	0.508 0.499		.499
6	Fwd Crosstube Lug Plate	0.940Inches ± 0.030	0.970 0.910		.940
7	Fwd Crosstube Lug Plate	4.470Inches ± 0.030	4.500 4.440		
8	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740		.751
9	Fwd Crosstube Lug Plate	8.470Inches ± 0.030	8.500 8.440		8.475
10	Fwd Crosstube Lug Plate	8.096Inches ± 0.010	8.106 8.086		
11	Fwd Crosstube Lug Plate	5.430Inches ± 0.030	5.460 5.400		
12	Fwd Crosstube Lug Plate	5.197Inches ± 0.010	5.207 5.187		
13	Fwd Crosstube Lug Plate	4.733Inches ± 0.010	4.743 4.723		
14	Fwd Crosstube Lug Plate	0.310Inches ± 0.010	0.320 0.300		0.313
15	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740		.751
16	Fwd Crosstube Lug Plate	0.375Inches ± 0.010	0.385 0.365		.377
17	Fwd Crosstube Lug Plate	1.840Inches ± 0.030	1.870 1.810		1.845
18	Fwd Crosstube Lug Plate	0.920Inches ± 0.030	0.950 0.890		0.920
19	Fwd Crosstube Lug Plate	3.000Inches ± 0.010	3.010 2.990		2.999
20	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740		.748

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21	Fwd Crosstube Lug Plate	0.625Inches $\pm$ 0.010	0.635 0.615	0.630
22	Fwd Crosstube Lug Plate	1.982Inches $\pm$ 0.010	1.992 1.972	1.982
23	Fwd Crosstube Lug Plate	0.991Inches $\pm$ 0.010	1.001 0.981	0.991
24	Fwd Crosstube Lug Plate	0.770Inches $\pm$ 0.030	0.800 0.740	
25	Fwd Crosstube Lug Plate	1.540Inches $\pm$ 0.030	1.570 1.510	
26	Fwd Crosstube Lug Plate	2.470Inches $\pm$ 0.030	2.500 2.440	
27	Fwd Crosstube Lug Plate	0.820Inches $\pm$ 0.030	0.850 0.790	
28	Fwd Crosstube Lug Plate	3.570Inches $\pm$ 0.030	3.600 3.540	
29	Fwd Crosstube Lug Plate	1.230Inches $\pm$ 0.030	1.260 1.200	
30	Fwd Crosstube Lug Plate	0.730Inches $\pm$ 0.030	0.760 0.700	
31	Fwd Crosstube Lug Plate	0.125Inches $\pm$ 0.010	0.135 0.115	
32	Fwd Crosstube Lug Plate	0.252Inches $\pm$ 0.030 - 0.000	0.282 0.252	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: _____			



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Container No: S185603



Part: D4148-1

Job No: 194371

Serial No/Batch: S185603

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/30/19